

Date: Monday, 27/04/2009 12:52:05 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT
Job Number	: 47540		
Estimate Number	: 10532		
P.O. Number	:	Part Number	: K10003
This Issue	: 27/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: 634, 635 IIN
First Issue	: / /	Project Number	: N/A
Previous Run	: 47216	Drawing Revision	: F
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 10/05/2009
Checked & Approved By	: <u>JUL 09 04.27</u>	Qty:	8
Comment	: Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est : L 07.01.12 Document Record for copying bluefile rmv KJ Est Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by: Est N 09.01.27 DSI 9418 rev B EC verified by: DD Est P 09.04.20 fixed pick list EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC



DOCUMENT CONTROL

802/06/18 18 for JLD
 09/06/03



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003

(CHG 006)

New Lugs.

(PTC)

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D2570

Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

24

D2570

Bushing

346431

8809/06/03 (XS)

4.0

D2571

Saddle, Fwd Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty

Part Number

Description

Batch

1



D2571

Saddle

39122

7x
 47564

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
6/16/18	1.0	update to chg 007 per ECN 08-588.				 6/16/18	 6/16/18	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE KIT

Job Number: 47540

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd In 205

11/11



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty

Part Number

Description

Batch

1

D2572

Saddle

B47565 x2

B47248 x6

8809/06/04 (X8)

6.0

D2573

Saddle, Aft Out 205

11/11



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty

Part Number

Description

Batch

1

D2573

Saddle

B47566

8809/06/04 (X8)

7.0

D2574

Saddle, Aft In 205

11/11



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, In

Pick:

Qty

Part Number

Description

Batch

1

D2574

Saddle

B47567 x6 B46955 x2

8809/06/04 (X8)

8.0

D3405041

Lug Assembly

11/11



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3405041

Lug Assembly

47200

8809/06/03 (X8)

9.0

D3405043

Lug Assembly

11/11



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3405043

Lug Assembly

47308

8809/06/03 (X8)

10.0

D2747

Set Screw

11/11



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Set Screw

Pick:

Qty

Part Number

Description

Batch

4

D2747

Socket Head Set Screw

B43855

8809/06/03 (X8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 47540

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2876

Spacer

B42364

SS 09/06/03 (x8)

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Saddle Spacer

Pick:

Qty

Part Number

Description

Batch

2

D2877

Spacer

B43857

SS 09/06/03 (x8)

13.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Set Screw

Batch:

B44644

SS 09/06/03 (x8)

14.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)
Bolt

Pick:

Qty

Part Number

Description

Batch

16

AN4-6A

Bolt

M110399*107
M110399*21

SS 09/06/03 (x8)

15.0

AN4C47A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)
BOLT

batch:

M111425

SS 09/06/03 (x8)

16.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)
Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M110328

SS 09/06/03 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 47540

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M111193 x31 M110372 x33

Com-? Error.

SS 09/06/03 (x8)

18.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M111279

SS 09/06/03 (x8)

19.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD616

Washer

M111193

SS 09/06/03 (x8)

20.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

Nut

Batch:

M110450

SS 09/06/03 (x8)

21.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tow Ring

batch:

B47309

SS 09/06/03 (x8)

22.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

46752

SS 09/06/03 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SADDLE KIT

Job Number: 47540

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS210434

Nut

H

~~HT~~



Comment: Qty.: 5.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut

batch:

M111819

SS 09/06/03 (18)

24.0

D34175

Washer

H

~~HT~~



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch:

44350 x15 B45916 x1

SS 09/06/03 (18)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

SS 09/06/03 (18)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

PK Rev 2

9/6/18

8x
50

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/22 HJ

Job Completion



U 09/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		AN960JD10L	* WASHER
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				AN960JD616	WASHER
29	16	16				AN4-6A	BOLT
30	32	32				AN960JD416	WASHER
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2786-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2786-3)
52					4	AN4C47A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: F
Date: 08.10.07

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RETURN TO
ENGINEERING
NOTICE
WORK ORDER
NO. 17540

5.0 D204-635-011 SKIDTUBE INSTALLATION PARTS LIST

Item	635 -011	635 -041	641 -011	Part Number	Description
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT
1		1		D2590-041	204 SKIDTUBE ASSEMBLY
2A		10		D2594-1	* PLUG
2B		10		D2594-3	* O-RING
3		1		D2855	* AFT CAP
4		2		AN3-5A	* BOLT
5		2		AN960JD10L	* WASHER
6A		1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B		1		D3566-1	* GASKET
7A		1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B		1		D3566-1	* GASKET
8A		1		D3564-7	* WEARSHOE (REPLACES D2577-7)
8B		1		D3566-7	* GASKET
9A		1		D3564-13	* WEARSHOE
9B		1		D3566-13	* GASKET
10		44		AN3C4A	* BOLT (REPLACES AN3-4A)
11		44		AN960C10L	* WASHER (REPLACES AN960JD10L)
12		44		ALS4-1032-130	* INSERT
13		2		ALS4-1032-225	* INSERT
20	1			D2571	SADDLE, FWD OUTSIDE
21	1			D2572	SADDLE, FWD INSIDE
22	1			D2573	SADDLE, AFT OUTSIDE
23	1			D2574	SADDLE, AFT INSIDE
24	8			AN4-51A	BOLT
25	16			D2570	BUSHINGS
26	8			MS21042L4	NUT (OR MS21042-4)
27	8			AN6-12A	BOLT
28	8			AN960JD616	WASHER
29	16			AN4-6A	BOLT
30	32			AN960JD416	WASHER
31	16			MS21042L4	NUT (OR MS21042-4)
32	4			D2747	SET SCREW
33	2			D3533-1	SET SCREW
40	1			D3407-041	TOW RING ASSEMBLY (REPLACES D2968-041)
41	1			D3456-1	WASHER
43	1			MS21043-4	NUT
44	2			D3417-5	WASHER
50			1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51			1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52			4	AN4C47A	BOLT
53			8	D2570	BUSHING
54			4	MS21043-4	NUT
60	2			D2876	SADDLE SPACER
61	2			D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

SHOP COPY
RETURN TO

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO 47500

